March-05-13 11:15:11 AM

Item ID: D3265-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Basket Base Assembly Start Date: 3/05/13 Start Qty: 1.00 **Cust Item ID:** Required Date: 4/17/13 **Req'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: Date: 13-03-5 Tooling: Approvals: Date: Date: _ _ ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Description Work Center ID **Run Hours** Qty Code **Qty** Number Stamp Draw Nbr **Revision Nbr** Ε D3265 100 Weld per dwg A/R S.S. rod Batch: 4/22357 0.00 Large Fab *100* Large Fab 0.00 Memo Large Fab 1- Assemble and weld as per Dwg D3265 using DT9444 2- Deburr and remove all markings from material as required 3- weld mesh as per dwg 110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 *110* QC 0.00 Memo Quality Control

DQA:	Date:	
DQA.	Date.	•

WORK ORDER NON-CONFORMANCE / UPDATE NCR: Yes / No

										QA Closed:	Date	
Work Orde	er:		· '-			DISPOSITION			AGAINST DI	EPARTMENT	/PROCESS	
Part I	Vo.		Rework Skid-tube Crosstube Water Jet E Scrap Machining Small Fab Prod. Eng. Coor. Use-as-is Thermoforming Finishing Rec/Store/Packaging Work Order Update Large Fab Composite Supplier						Engineering Quality Other			
0				<u> </u>	Doscri	ption of work order update	Initia		Action	Sign &		
Root		Data	Cton	0411	1	or Non-conformance	Chief E	Į.	escription	Date	Verification	QC Inspector
Cause	1	Date	Step	Qty		or Non-comormance	Ciller El	ig Dr	escription	Date	Vermeation	Qe mspector
Doc/Data	-	-										
Equip/Tooling Operator		1										
Material		[
Setup		1.				•						
Other	_	1]					
Process	-	1										
Supplier	┢	1			}		1					
Training	_		1							1.		
Unapproved	-	1										
	l		·			F	AULT CA	TEGORY				
Landi	ng (Gear				General						
	Ť	Bending				Bend	Grai	n		Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	rtolerance	Temperature/Cure
		Cracks				Broken/Damaged	inspe	ection Incomplete	e	Part Incorre	ect	Weld
3 0		Crushed/	Crimped.			Burrs	Instr	uctions Incomple	ete/Unclear	Part Lost/M	lissing	Wrong Stock Pulled
2 *		Cuffs Contamination		Mai	ntenance		Part Moved					
	Heat Treat Countersink		Misla	abeled		Positioned	Wrong					
Inspection Strip in Tube Cut Too Short			Misr	ead		Power Loss,	/Surge	Other				
Ripples in Bend Drill Holes				Offse	et							
	Torque Waves in Extrusion Drawing			Out	of Calibration							
	Turning Sequence Finish			Out	of Sequence							
		Wave/Tw	ist in Tub	oe		Folio	Outs	ide Dimensions				

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Insp.

March-05-13 11:15:11 AM

Item ID: D3265-041 Accept *N900040100* Setup Start **Revision ID:** Basket Base Assembly Item Name: **Start Date:** 3/05/13 Start Oty: 1.00 **Cust Item ID:** Required Date: 4/17/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: Approvals: **Tooling:** Date: Stop QC: _____ Date:___ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Work Center ID Description Qty **Run Hours** Qty Code Number Stamp 120. QC6- Inspect dimensions to drawing 0.00 *120* 0.00 Memo Quality Control 130 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 *130* Powdercoat Memo Powder Coating IST COAT: START TIME: OVEN TEMPERATURE: FINISH TIME:

W125620

****if necessary** OVEN TEMPERATURE

2ND COAT:

START TIME:

FINISH TIME:

DQA:	Date:	:_	

		,	
NCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date:	
Work Orde	ar.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Mention											
Root				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator										·	
Material Setup											
Other Process	ਦਾ										
Supplier Training								**			
Unapproved			<u> </u>			<u> </u>					
· · · · · · · · · · · · · · · · · · ·						AULT CAT	GORY				
Landir	ng Gear Bending	5			General Bend	Grain			Ovalized		Pressure/Forced
	Centre Cracks	Not Conce	ntric to	o/s	BOM/Route Broken/Damaged	Hardw Inspec	are tion Incomplete		Over/Under tolerance Part Incorrect		Temperature/Cure Weld
	Crushed	d/Crimped			Burrs	Instruc	tions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance		Part Moved	•	
	Heat Treat Countersink		Mislab	eled		Positioned \	Vrong				
	Inspect	ion Strip in	Tube		Cut Too Short	Misrea	ıd		Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes	Offset					
. [Torque	Waves in	Extrusio	n [Drawing	Out of	Calibration				
	Turning Sequence Finish				Out of	Out of Sequence					
	Wave/Twist in Tube Folio				Outsid	Outside Dimensions					

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March-05-13 11:15:11 AM

Item ID:

Required Date: 4/17/13

D3265-041

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name:

Basket Base Assembly

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Date:

Tool # Plan

Code

3/05/13

Date:

SPC (Y/N):

Date:

Stop

Run

Sequence ID/ **Work Center ID**

Operation Description

QC3- Inspect Part Finish

Set Up/ **Run Hours**

Qty

Accept

Reject Qty

Reject Number Stamp

140

Quality Control

140

Memo

0.00

0.00

0.00

150

Small Fab

150 Small Fab

Small Fab

Memo

0.00

Expiry date:

160

QC5- Inspect part completeness to step on W/O

0.00

160

Quality Control

Memo

0.00

DQA:	Date:	ſ

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No QA Closed: Date: AGAINST DEPARTMENT/PROCESS DISPOSITION Work Order: Engineering Skid-tube Crosstube Water Jet Rework Machining Small Fab Prod. Eng. Coor. Quality Part No. Scrap Rec/Store/Packaging Thermoforming Finishing Other Use-as-is Composite Supplier NCR No. Large Fab Work Order Update Description of work order update Initial Action Sign & Root Step or Non-conformance Chief Eng Description Date Verification QC Inspector Qty Cause Date Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY** General **Landing Gear** Grain Ovalized Pressure/Forced Bend Bending BOM/Route Temperature/Cure Hardware Over/Under tolerance Centre Not Concentric to O/S Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Part Lost/Missing Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Moved Maintenance Cuffs Contamination Positioned Wrong Mislabeled Heat Treat Countersink Other Power Loss/Surge Inspection Strip in Tube Cut Too Short Misread Offset Ripples in Bend **Drill Holes** Torque Waves in Extrusion Drawing Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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98055

Page 4

March-05-13 1	1:15:11 AM			981	ານນ			Pag
Item ID; Revision ID:	D3265-041			Accept	*N900040	100*	Setup Start	*NS1*
Item Name:	Basket Base	Assembly			'		Stop	*NC2*
Start Date:	3/05/13	Start Qty: 1.00	*1*		Cust Item ID:			14112
Required Date:	4/17/13	Req'd Qty: 1.00	*1*		Customer:			
Reference:			- -					į
Approvals:	Process Pla	an:	Date:	Tooling:	Date:		Run Start	*NR1*
	QC:		Date:	SPC (Y/N):	Date:	·	Stop	*NR2*
Sequence ID/ Work Center II)	Operation Description Identify as per dwg & Sto	ock Location:D356	Set Up/ Run Hours -GGF - H5	Tool ID Tool #	Plan Acce Code Qty	- •	Reject Insp. Number Stamp
170 Packaging Packaging		Мето	7.	0.00	7000	1	1_\$	JOB 13-5-15
180		QC21- Final Inspection -	Work Order Release	0.00			13/5	5/194
180 QC		Memo		0.00			_ ' / /	
Quality Control		,'		0.00			,	MF 25-15
4.								25-17

									DQA:	Date:	/ JR	
NCR: Y	es / No				WORK ORDER NON-O	CONF	ORN	AANCE / UPDATE				
									QA Closed:	Date:		
Work Orde	r·				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
work Orde	·				Rework			Skid-tube Crosstube		Water Jet	Engineering	
Part N	0.				Scrap		ŀ	Machining Small Fab		d. Eng. Coor.	Quality	
					Use-as-is] '		noforming Finishing		re/Packaging	Other	
NCR N	0.			 	Work Order Update]		Large Fab Composite		Supplier		
Root		Ţ		Descri	ption of work order update	Ini	itial	Action	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Description	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator			•									
Material			,				ļ					
Setup						1						
Other												
Process		ļ			•				1			
Supplier							}					
Training						}						
Unapproved		<u> </u>				.				<u> </u>		
	<u> </u>				F	AULT	CATE	GORY				
Landir	ng Gear				General					_	٦ ا	
	Bending				Bend	∐ G	Grain		Ovalized	ļ	Pressure/Forced	
	Centre N	ot Conce	ntric to	o/s	_BOM/Route	Шн	lardwa	re	Over/Under	tolerance	Temperature/Cure	
[Cracks				Broken/Damaged	∐ Ir	ıspecti	on Incomplete	Part Incorre	ct	Weld	
	Crushed/	Crimped.			Burrs	∐ lr	ıstruct	ions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	\\	⁄lainte	enance	Part Moved			
	Heat Treat Countersink					□□	∕iislabe	eled	Positioned	Wrong		
Ī	Inspectio	n Strip in	Tube		Cut Too Short Misread Power Loss/Surge Other						Other	
	Ripples in	n Bend			Drill Holes		Offset				· · · · · · · · · · · · · · · · · · ·	
<u> </u>	Torque W	Vaves in E	xtrusio	n	Drawing	Пс	of (Calibration				
Ţ	Turning S	equence			Finish		of S	Sequence				
		ave/Twist in Tube Folio Outside Dimensions										

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Picklist Print

March-05-13 11:15:16 AM

Work Order ID: 98055

98055

Parent Item:

D3265-041

D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 3/05/13

Required Date: 4/17/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:C Re-Format 05-11-03 JLM

IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verf: by:EC IPP RevE: as per DEO DD 10.09.12 verified by:EC IPP RevF: revise seq

IPP REV:G 12.07.26 AS PER

88209

110 DD 10.01.28 verified by:EC DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status
D2232-3		Manufactured	No			100	Each	16.0000	2	2		
D232-3									**	B 98	040 >c	Qv
Susket Times				Location		Loc (<u>Oty</u>	Loc Code		•	SY 13	05.08
				WA004			16					1
					75581		2		_		_	
				:	89358		14		_			
D2235-I		Manufactured	No			100	Each	13.0000	i	1		ı
D2235-1									**	B 96	545)	13.05.0
				Location		Loc (<u>Oty</u>	Loc Code			SY	13.05.0
				WA004			13		_		_	_
					66895		4		_		_	
				;	85602		4		_		_	
					86051		1				_	

									DQA:	Date:	· e
NCR: Y	es / No				WORK ORDER NON-C	CONFORT	MANCE / UI	PDATE	QA Closed:	Date:	
					DISPOSITION			AGAINST DE	and the same of th		
Work Orde	r:				Rework Skid-tube Crosstuk		Crosstube	Water Jet		Engineering	
Part No.					Rework Scrap	1 1	Machining	Small Fab		d. Eng. Coor.	Quality
NCR N	lo			<u>.</u>	Use-as-is Work Order Update	Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	А	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator			<u> </u>	j							
Material		1							:		
Setup											
Other		·									
Process											
Supplier									•		
Training											•
Unapproved			<u> </u>			<u> </u>			<u> </u>		
						AULT CATE	GORY	···-			
Landin	ng Gear			_	General			· —	1	_	1_
	Bending			-	Bend	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
 				o/s	BOM/Route	Hardwa			Over/Under	<u> </u>	Temperature/Cure
	Cracks				Broken/Damaged	⊢ ⊢ `	ion Incomplete		Part Incorre	├	Weld
Crushed/Crimped. Burrs					Burrs		tions Incomplete	e/Unclear	Part Lost/M	L	Wrong Stock Pulled
Cuffs					Contamination	Mainte	enance		Part Moved		
	Heat Tre	at			Countersink	Mislabe	eled		Positioned Wrong		7
[Inspection Strip in Tube				Cut Too Short	Misrea	d	ļ	Power Loss	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-05-13 11:15:16 AM

Work Order ID: 98055

Parent Item:

D2581

D3265-041

98055

Parent Item Name: Basket Base Assembly

D3265-041

100

Each

48.0000

Start Date: 3/05/13

Required Date: 4/17/13

Start Qty: 1.00

Required Qty: 1.00

DJ 13.08.08

B98503 -> JX

Mounting Bracket

<u>Location</u>	Loc Qty	Loc Code
WA004	48	
70766	2	
81253	1	
82506	2	
83230	3	
85452	2	

D3265-043

Rib Assembly

D3265-1

Manufactured

Manufactured

Manufactured

No

No

87706

92871 94204

> Loc Qty 5

90134

100

100

5 Each

2 10

26

Each

15.0000

**

**

3 96745 SS 13-05-08

B90134 SJ13.05.08

D3265-1 Rib

D3265-043

Location Loc Oty WA005 96745

WA006

Location

WA004

51483 55842

Loc Code

5.0000

Loc Code

DQA:	:Date:		· •
	 _	 	

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Engineering Skid-tube Water Jet Crosstube Rework Part No. Small Fab Prod. Eng. Coor. Quality Machining Scrap Rec/Store/Packaging Other Thermoforming Finishing Use-as-is Large Fab Composite Supplier Work Order Update NCR No. Description of work order update Action Sign & Initial Root Date Verification QC Inspector Chief Eng or Non-conformance Description Cause Date Step Qty Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending Temperature/Cure Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Weld Broken/Damaged Part Incorrect Cracks Inspection Incomplete Wrong Stock Pulled Part Lost/Missing Crushed/Crimped. Instructions Incomplete/Unclear Burrs Part Moved Maintenance Cuffs Contamination Positioned Wrong Mislabeled Countersink Heat Treat Power Loss/Surge Other Misread Cut Too Short Inspection Strip in Tube Offset **Drill Holes** Ripples in Bend Drawing Out of Calibration **Torque Waves in Extrusion** Out of Sequence Turning Sequence Finish -

Outside Dimensions

Wave/Twist in Tube

Folio

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March-05-13 11:15:16 AM

Work Order ID: 98055

98055

Parent Item:

D3265-041

D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 3/05/13

Required Date: 4/17/13

Start Qty: 1.00

Required Qty: 1.00

D3265-5

Manufactured

100

Each 8.0000

D3265-5

Location WA

96886

Loc Qty 8 Loc Code

AH13.05.08

D3442-5

Manufactured

100

Each

12

2

Each

12.0000

3 868 36 → Øx

33282

Loc Code

D3825-041

D3826-041

Manufactured No

Manufactured

86836

Location

WA004

10 100 Each

Loc Qty

Loc Qty

16.0000

Rib Assembly (Basket End)

Location WA004

89380 89450 16 12 4

100

Loc Code

10.0000

2

**

Rib / Gusset Assembly

Location Loc Qty WA004 90838 WA007 90722

Loc Code

March-05-13 11:15:17 AM

Shop Packet Print

Page 3

DQA:	Date:	•
DQA.	Date.	•

NCR: Yes / No WORK ORDER NO

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date:	and the state of t			
Work Orde	ır.				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other			
Root					iption of work order update	Initial	Actio		Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descrip	otion	Date	Verification	QC Inspector			
Doc/Data	_	}			1									
Equip/Tooling														
Operator	→ `													
Material .	_													
Setup					ı									
Other					:					•				
Process	_													
Supplier		1												
Training	' 、	1			1		† †							
Unapproved		<u> </u>	<u> </u>			AULT CATE	GORY		Land Mark Control	<u> </u>				
Landir	ng Gear				General	AUL: CATE	<u> </u>							
Lanuii	Bending			Г	Bend	Grain			Ovalized		Pressure/Forced			
	Centre No	ot Conce	ntric to 6	_{1/5}	BOM/Route	Hardwa	are :		Over/Under	tolerance	Temperature/Cure			
	Cracks	or correct		,, <u> </u>	Broken/Damaged		ion Incomplete		Part Incorre		Weld			
	Crushed/	Crimped		-	Burrs	—	tions incomplete/Un	nclear	Part Lost/Mi	, <u> </u>	Wrong Stock Pulled			
ŀ	Cuffs				Contamination	\vdash	enance		Part Moved	_				
Ì	Heat Trea	at			Countersink	Mislabe			Positioned V	Vrong				
Ì	Inspectio		Tube		Cut Too Short	Misrea			Power Loss/	· —	Other			
ľ	Ripples in				Drill Holes	Offset								
ľ	Torque W		Extrusio	1	Drawing	Out of	Calibration			-				
ľ	Turning S				Finish	Out of	Sequence							
Ī	Wave/Tw	ist in Tul	эe		Folio	Outside	e Dimensions							

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March-05-13 11:15:17 AM

Work Order ID: 98055

Parent Item:

D3265-041

98055

No

Parent Item Name: Basket Base Assembly

D3265-041

Start Date: 3/05/13

Required Date: 4/17/13

Start Qty: 1.00

Required Qty: 1.00

D3832-11

Manufactured

100

Each

B 97221

D3832-11

Mesh (Base)

Location WA004

Loc Qty -1Loc Code

1.0000

M13 05 08

D3833-1

Manufactured No 90140

100

Each

14.0000

Mesh (Base End Face)

Location Loc Qty WA007 77521 81259 89208 92602

Loc Code

**

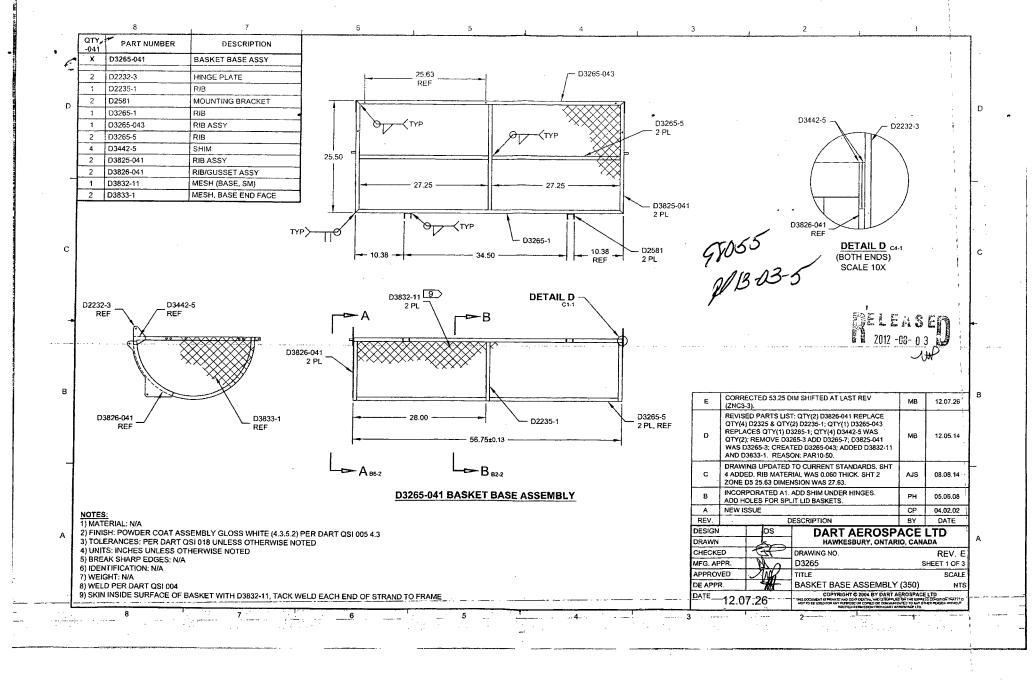
									DQA:	Date:	•
NCR: Yes	s / No				WORK ORDER NON-C	DATE	QA Closed:	 Date:			
Work Order:		<u></u>			DISPOSITION AGAINST DE			EPARTMENT/PROCESS			
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	· .			Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	g Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup	-		-								

Landing	Gear	General				•		
	Bending	Bend		Grain	L	Ovalized	L	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	L	Part Incorrect		Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	L	Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination		Maintenance		Part Moved		
	Heat Treat	Countersink		Mislabeled		Positioned Wrong	_	-
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge		Other
	Ripples in Bend	Drill Holes		Offset				
	Torque Waves in Extrusion	Drawing		Out of Calibration				
	Turning Sequence	Finish		Out of Sequence				
	Wave/Twist in Tube	Folio		Outside Dimensions				

FAULT CATEGORY

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Other
Process
Supplier
Training
Unapproved



					0					DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	CON	NFORN	MANCE / UP	PDATE	QA Closed:	 Date:	
			re-sit		DISPOSITION				AGAINST DE	· Training the property of the contract of the		CONTROL SECTION OF THE PROPERTY AND THE SECTION OF
Work Orde	er:				Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap	Machining Small Fab Prod. Eng. Coor.					Quality	
					Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update	╛┃		Large Fab	Composite]	Supplier	
Root					iption of work order update		nitial		ction	Sign &		100
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data					ı							
Equip/Tooling						ł						
Operator					ı							
Material												
Setup		İ	1 1									
Other	_						İ					
Process		1										
Supplier		ł										
Training												
Unapproved		1	<u> </u>				T 64 TF	2004			<u> </u>	
						AUL	T CATE	JORY				
Landii	ng Gear			Γ-	General		Grain			Ovalized	Г	Pressure/Forced
	Bending			\	Bend BOM/Route	\vdash	Hardwa		 -	Over/Under	tolorance	Temperature/Cure
	Centre No	ot Conce	ntric to C)/S -	=	\vdash	1		-	Part Incorre	 	Weld
	Cracks	·		-	Broken/Damaged		1	on Incomplete ions Incomplete	/Uncloar	Part Lost/M		Wrong Stock Pulled
	Crushed/	Crimpea		-	Burrs Contamination	\vdash	Mainte	•	Jonesai	Part Moved	· -	
	Cuffs	. +			Countersink	\vdash	Mislabe		 	Positioned \		
	Heat Trea		Tubo	· -	Cut Too Short	-	Misread			Power Loss,		Other
}	Inspectio		rune	-	Drill Holes	-	Offset	•		7, ower 1022)		Totale)
	Ripples in		Externolog		-	-	ł	Calibration				
1	Torque W	vaves in t	excrusion	1	Drawing Out of Calibration							

Out of Sequence

Outside Dimensions

Turning Sequence

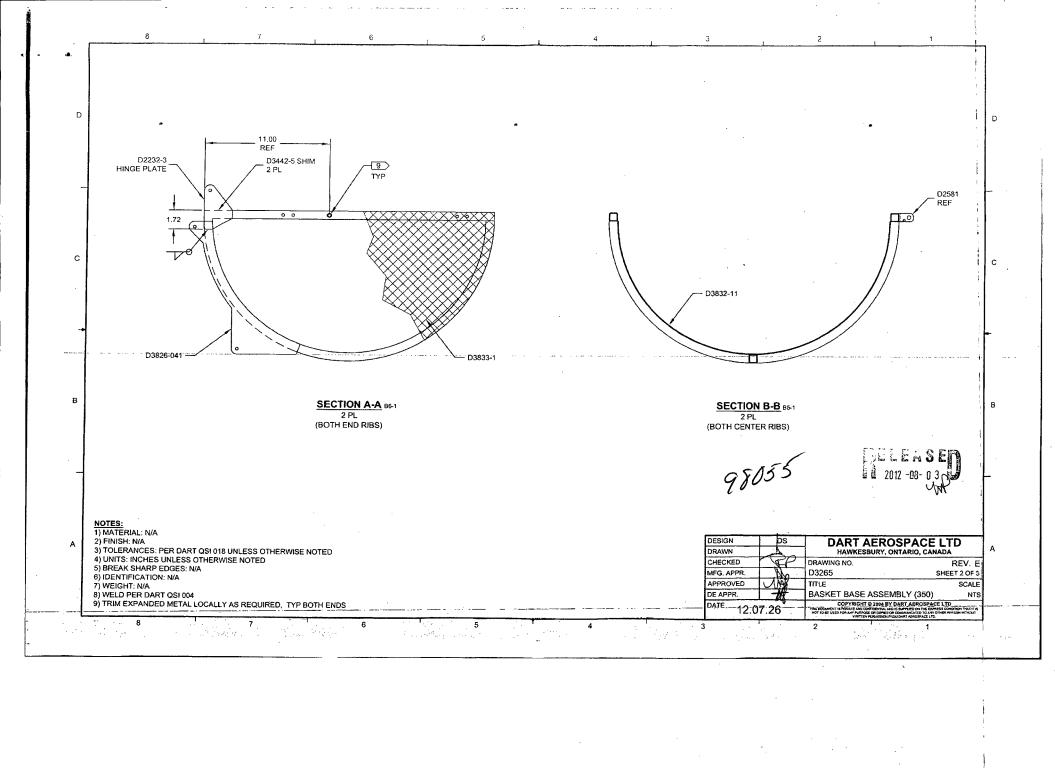
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

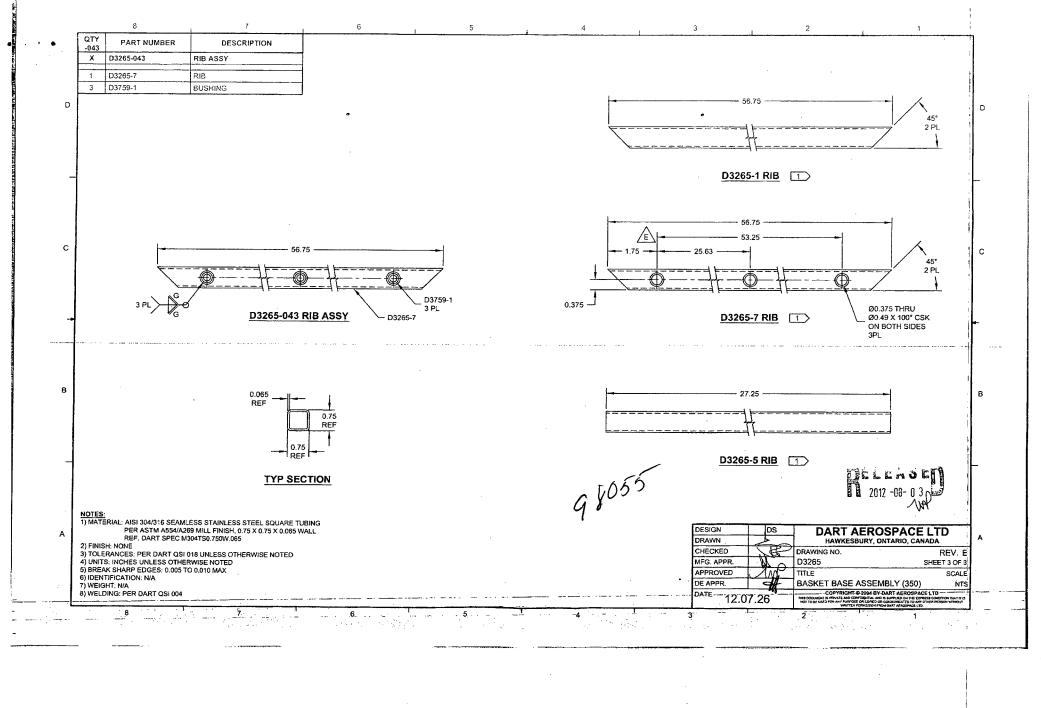
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		DQA:	Date:	£
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		-	

										QA Closed:	Date	e:			
Work Orde	or'					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
WORK Orac	·'· —					Rework] [Skid-tube	Crosstube		Water Jet	Engineering			
Part No.						Scrap	1 Ⅰ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
		•				Use-as-is	The	rmoforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR No.					Work Order Update]	Large Fab	Composite		Supplier					
							la isia l		Action	Sign &	<u> </u>				
Root			۱	٠.	l	ption of work order update	Initial	·		Date	Verification	QC Inspector			
Cause	\vdash	Date	Step	Qty	(or Non-conformance	Chief Er	ig De	scription	Date	verification	QC IIIspector			
Doc/Data	Щ														
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	_	_	ot Concei	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance [Temperature/Cure			
	\Box c	racks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld			
	$\prod c$	rushed/	Crimped.			Burrs	Instr	uctions Incomplet	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	C	uffs				Contamination	Mair	ntenance	<u> </u>	Part Moved					
	Шн	leat Trea	ıt			Countersink	Misla	beled		Positioned \					
	lr	nspection	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss,	/Surge	Other			
	R	lipples in	Bend			Drill Holes	Offse	t							
	Шт	orque W	aves in E	Extrusio	n [_	Drawing	Out	of Calibration							
	Шт	urning S	equence			Finish	Out of Sequence								
1	Wave/Twist in Tube					Folio	Outside Dimensions								

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												DQA:	D.	ate:	4
NCR:	Yes ,	/ No				WORK ORDER NON-CONFORMANCE / UPDATE						QA Closed:	D.	ate:	
		' (*.				DISPOSITION AGAINST				PARTMENT/	PROCESS	*** \$4.00			
Work Orde	er: _								Chief tubo	Crosstuha		Water Jet			Engineering
Part No.					Scrap Use-as-is					Prod. Eng. Coor. Rec/Store/Packaging			Quality Other		
NCR No.					Work Order Update			Large Fab	Composite		Supplier				
Root				ĺ	Descri	ption of work order update	l	Initial	Acti	on		Sign &	- - -		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descri	ption		Date	Verification	on	QC Inspector
Doc/Data															
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Operator			•		i	N. 4			No.					ſ	
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Other															
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	L I ^E	Bending				Bend	_	Grain			\vdash	Ovalized		<u> </u>	Pressure/Forced
		entre No	ot Conce	ntric to	O/S	BOM/Route	_	Hardwa			<u> </u>	Over/Under		\vdash	Temperature/Cure
	\mathbf{H}	cracks			_	Broken/Damaged	<u> </u>	-1	ion Incomplete		_	Part Incorre		-	Weld
	_		Crimped			Burrs	<u> </u>	-	ions Incomplete/U	nclear	_	Part Lost/M	issing		Wrong Stock Pulled
	\Box ^c	uffs				Contamination	<u>_</u>	Mainte			<u></u>	Part Moved			
	Ш⊦	ieat Trea	it			Countersink	_	Mislabe			_	Positioned V		_	· 7 .
		nspectio	n Strip in	Tube		Cut Too Short		Misread	d			Power Loss/	Surge	L	Other
	Ripples in Bend					Drill Holes	Offset								

Drawing

Finish Folio Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

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